

Date: Thursday, 15/05/2008 8:10:00 AM
 User: Linda Lacelle

ASAK Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARSHOE

Job Number : 39278

Estimate Number : 13315

P.O. Number :

This Issue : 15/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 11 Type : R & D SM/MED FAB

Previous Run : 39253

Part Number : D37933

Drawing Number : PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 22/05/2008

 POSITIVE
 RECALL

Qty: 40 Um: Each

Written By : _____

Checked & Approved By : _____

Comment : Est Rev:A 08-05-13 new issue DD verified by:

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet

1.248



51.907

adjusted



Comment: Qty.: 0.5733 sf(s)/Unit Total: 22.9320 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 107909

IB 8-5-20

35,046

was 28 in total

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3793

Dwg Rev: A

IB 8-5-20

Prog Rev: A

2-Deburr if necessary

IB 8-5-20

 Ph →
 3rd to last page

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-5-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

Scrap

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Drawing Name: WEARSHOE

Job Number: 39278

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description:

~~3 Form legible on brake using dig as per Dwg D37933~~

11/05/15

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 11/05/15

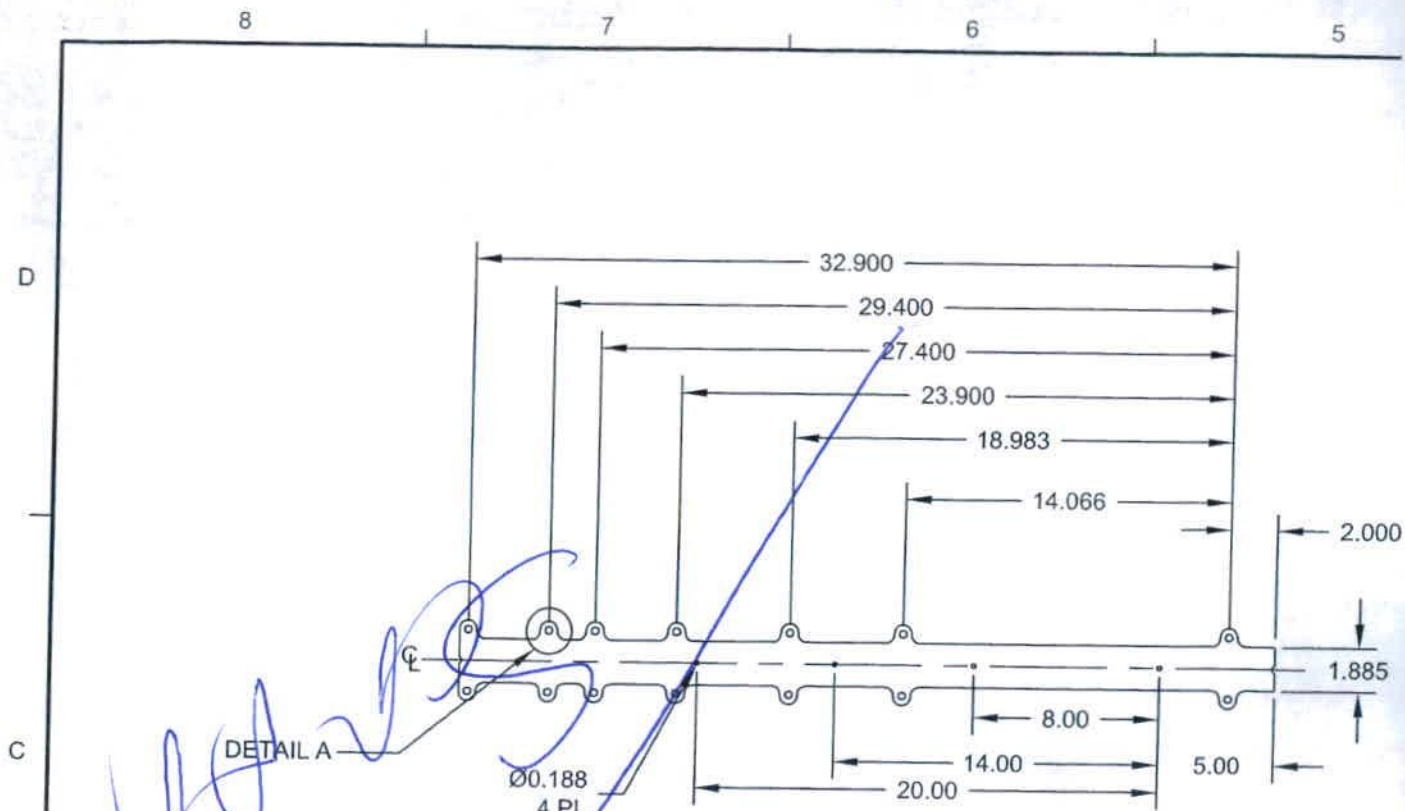
RELEASED _____

AUTH LL

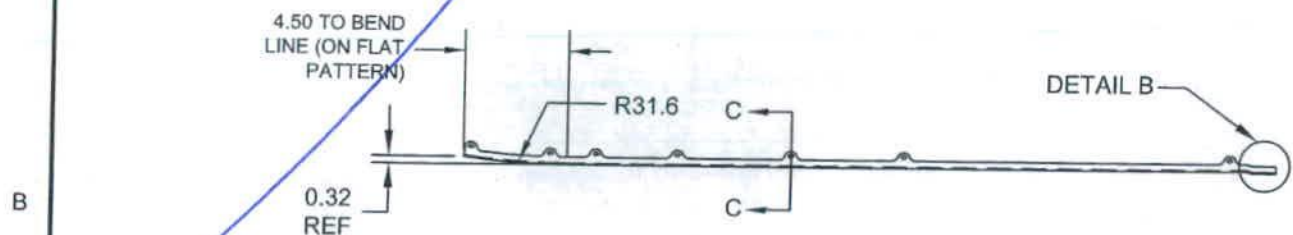
DATE _____

pull on 00249

MF 08-05-27



D3793-1F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

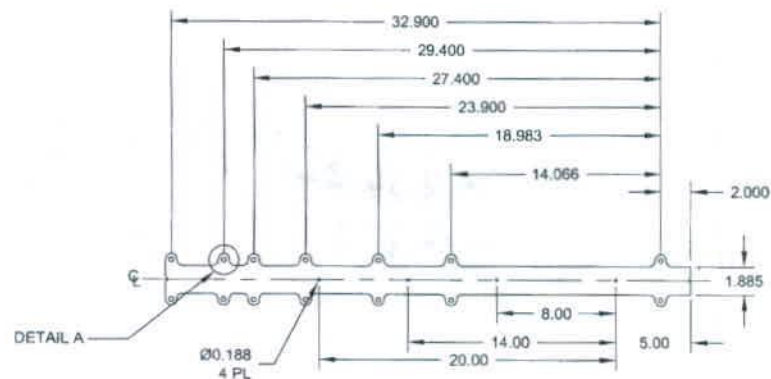
Part No: D3793-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/05/21
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

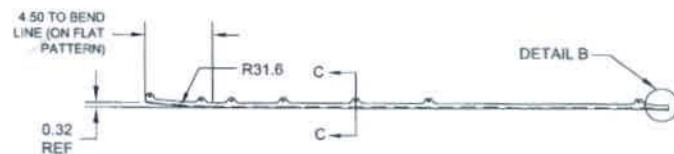
NCR: 39278-2

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	#	Parts has been modified to meet new Eng. change Parts were all ready in production Before change was sent.	PA QSI 042 08.05.21	Parts are accepted acceptable as per Eng. change Re. work	18-5-21 PA	08/05/21	QSI 042 08.05.21	08/05/21
		A 0.531" x 0.780" obround also also were plate 6.547 was changed for 6.444.						
08/05/21	3.0	The 0.531" x 0.780" obround was machined in machines and given a be unscrutable finish. R.C. Parts were tried to be saved Due to eng change during production	QSI 042	After talking with Peter Han it was decided to scrap the 15 parts for fit issues. Scrap: destroy Qty 15 No replace	QSI 042 08/05/21	08/05/21	QSI 042 08/05/21	08/05/21

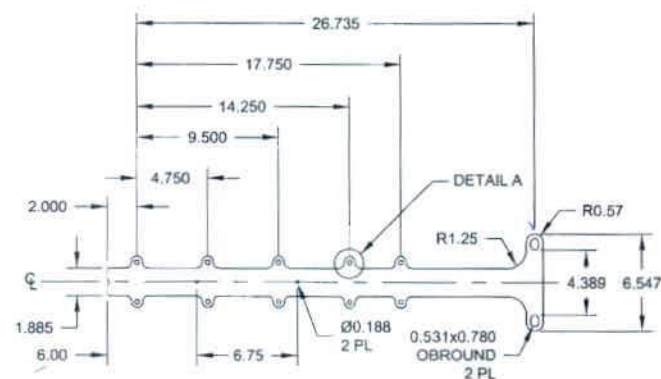
NOTE: Date & initial all entries



D3793-1F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3F FLAT PATTERN



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE		08.05.14
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

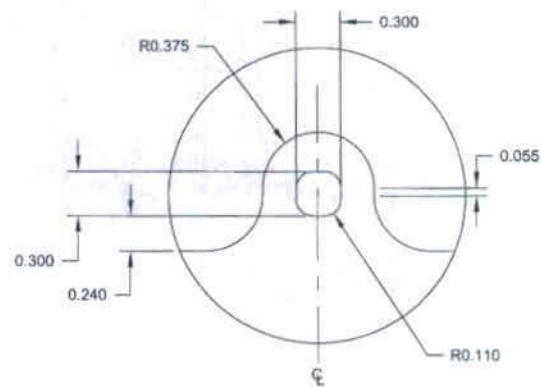
DRAWING NO. D3793
TITLE WEARSHOE
REV. A
SHEET 1 OF 2
SCALE NTS

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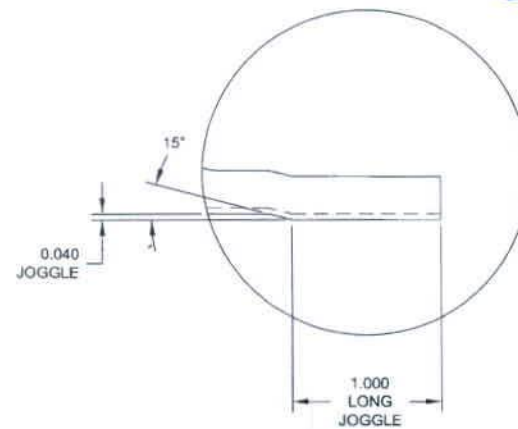
W/O 39278-2

RELEASED
08.05.2014

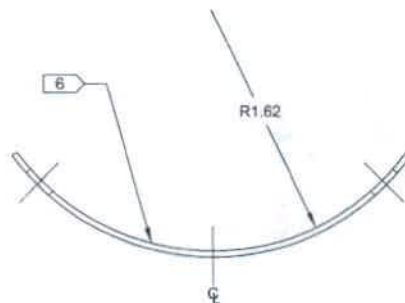
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1

